



NOTES

1. SPECIFICATIONS AND DIMENSIONS FOR THE CONTROL OF MANUFACTURING OPERATIONS ARE APPROXIMATE.

1. PRELIM REQUIREMENTS: DIMENSIONS FOR BAC 500 WELDING AND BRACING SPECIFICATIONS FOR BAC 202	2. TEST METHODS: THE BAC 500 BOLT & NUT INSTALLATION PER BAC 500 PULL TEST PER DOCUMENT BAC 500
3. FORM: INFORMATION & TEST RESULTS PER BAC 500 4. INSPECTION: QUALIFICATION & DOCUMENTATION PER BAC 500	5. MATERIALS: DIMENSIONS FOR BAC 500 6. FACTORY: DIMENSIONS FOR BAC 500

2. THE 145G03004 PULLER ASSY. IS TO BE USED IN CONJUNCTION
WITH AN ARBOR PRESS TO REMOVE HALF OF THE INNER RACE OF
THE 145D5506 BEARING FROM THE 145D5206 PINION GEAR OF THE
145D6300 COMB. XMSN.

3. ESTIMATED WEIGHT OF THE 145G0302-1: 40 LBS
ESTIMATED CUBE OF THE 145G0302-1: 9.0x9.0x11.0
4. BREAK ALL SHARP CORNERS .050R MIN.
5. WELD AND STRESS RELIEVE PER BAC 5915
CLASS "C" TYPE II (PULLER METAL TO BE E 6013, E7018,
LINDE 32, LINDE 65 OR EQUIV.)

6. THIS DESIGN PER MIL-S-8812.
7. CONSTRUCTION IN ACCORDANCE WITH MIL-STD-130 USING BOERING TOOL
DESIGN MANUAL VTD-II & BAC 5307.

8. BOEING HELICOPTERS
PHILPA. PA. 19142
CODE IDENT. NO 7722

9. CARR-LANE MFG. CO.
ST. LOUIS, MO. 63118-0129
CODE IDENT. NO 99842

10. APPLY A LIGHT COAT OF OIL PER MIL-L-7808 TO ALL
STEEL SURFACES.

11. STEEL STAMP USING .25 HIGH CHARACTERS AS SHOWN ON FID.

12. FILL IN CHARACTERS USING BLACK PAINT (NO SPC. REQ'D).

13. HEAT TREAT TO ROCKWELL "C" 40-43 (180-200KSI).

14. MTL: ALUM ROUND 6061-T651 PER QQ-A 225/8.

15. BOND - S RUBBER PAD TO 2ND WELDMENT AS SHOWN.
24 PSI PER BAC 6010 TYPE 40.

16. MTL: STL PLATE ASTM A36.

17. MTL: DRAWN OVER MANDRILL (DOM) WELDED STL TUBE 102% PER UNS G10260.

18. MTL: STL. PLATE A340 PER UNS G 4340.

19. MTL: STL. FLAT 1018 PER ASTM A-108.

20. MACHINED SURFACES TO BE .05 UNLESS OTHERWISE NOTED.

21. FINISH PER MIL-C-5541 CLASS 1A AND BOEING PROCESS SPEC
M5S G16 (MILBORE) OR ANODIZE PER MIL-A-8626 TYPE III, CLASS 1.

22. MTL: SYNTHETIC RUBBER SHEET PER MIL-R-68551, CLASS 1, GRADE G0.

23. THE 145G0302-1 BEARING PULLER HAS BEEN SUCCESSFULLY DEMONSTRATED.
24. THE DEMONSTRATION DEMONSTRATION REPORT NO 47-464P ON 17 JULY 1991.